

Date: Thursday, 11/23/2006 11:56:25 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT WELDMENT ASSY
Job Number	: 29676		
Estimate Number	: 10569		
P.O. Number	: WIA	Part Number	: D34437
This Issue	: 11/23/2006 S.O. No. : N/A	Drawing Number	: D3443 REV.B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: B
Previous Run	: 28233	Material	: WIA
Written By	: <u> </u>	Due Date	: 12/5/2006 Qty: 6 Um: Each
Checked & Approved By	: <u> </u>		
Comment	: A 05.11.14 New issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W120	Inventory
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Comment: Qty.: 0.7875 f(s)/Unit Total: 4.7250 f(s)
 AISI 304 SS seamless tubing 0.750" OD x 0.120" wall
 (M304TR0750W120)
 Batch: 1101945

SAD 06:12:07

(6)

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 1- Form as per Dwg D3443 using DT8117
 2- Deburr per dwg D3443

SB 06/12/13 (6)

SAD 06:12:07 (6)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

11/06/12/07 (6)

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1- Mill end to length and drill hole as per dwg D3443
 2-Deburr as per dwg D3443

DISP 07/01/04 6

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DISP 07/01/04 6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: 12 Date: 07/01/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/01/04</u>		<u>Dimension 8.47</u> <u>over of 0.017</u>			<u>07/01/04</u>			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT WELDMENT ASSY

Job Number: 29676

Part Number: D34437

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 07/01/08 6

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51-45435

07/01/08 (6) 12/1/08

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/08 (6)

Job Completion



12/07/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

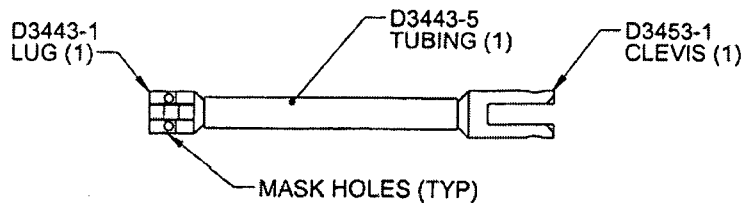
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

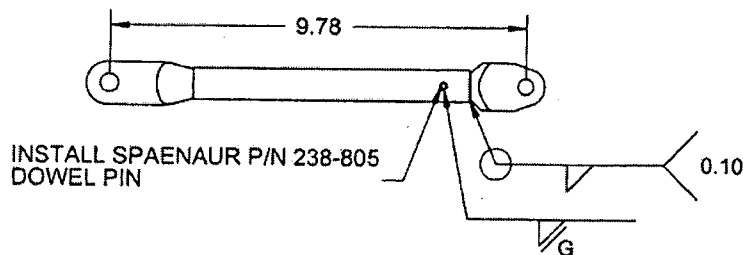
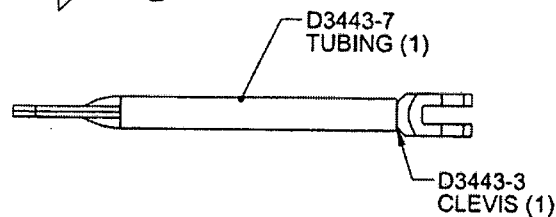
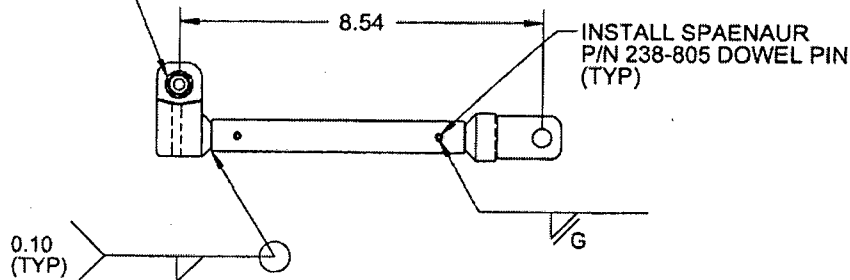
NOTE: Date & initial all entries

DART

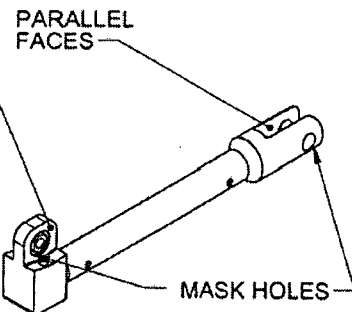
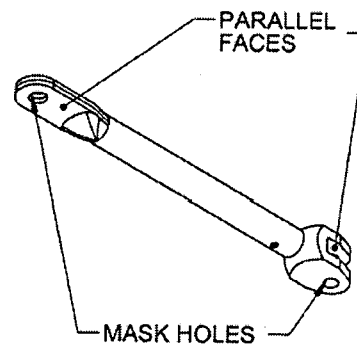
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3443	REV. B SHEET 1 OF 3
DATE 05.12.05		TITLE STRUT WELDMENT ASSEMBLY	SCALE 1:4
A	05.09.02	NEW ISSUE	
B	05.12.05	ADDED -9 PIN; REMOVED BALL PLUNGER; REVISE TOLERANCE; & $\phi 0.125$ WAS #30	

RELEASED05.12.09 *#*

PRESS FIT McMASTER-CARR P/N 63215K32
BALL JOINT BEARING AFTER POWDER COAT

**NOTES:**

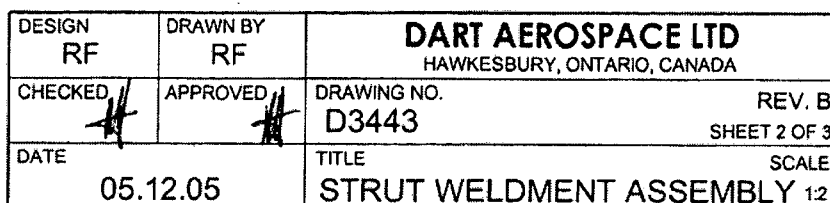
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

**D3443-041****D3443-043**

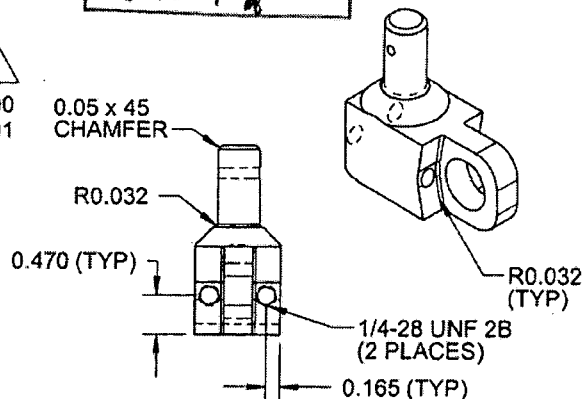
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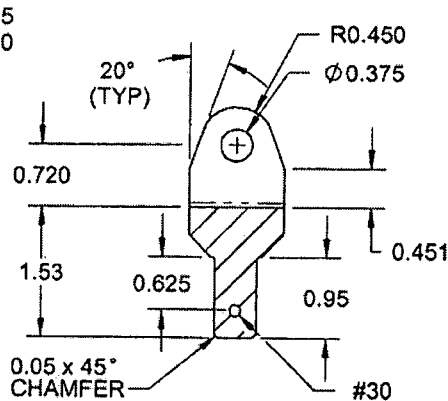
05.12.09



D3443-1 LUG

D3443-1 NOTES:

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC M17-4B)



SECTION A-A

D3443-3 CLEVIS

D3443-3 NOTES:

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)

GENERAL NOTES:

- 2) FINISH: NONE
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

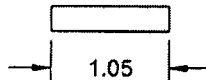
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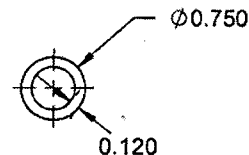
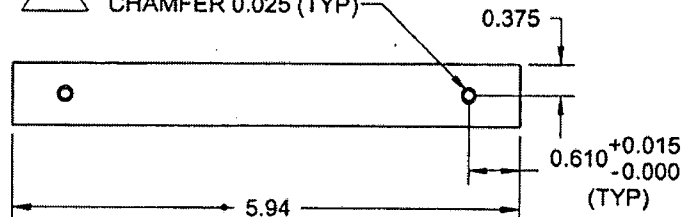
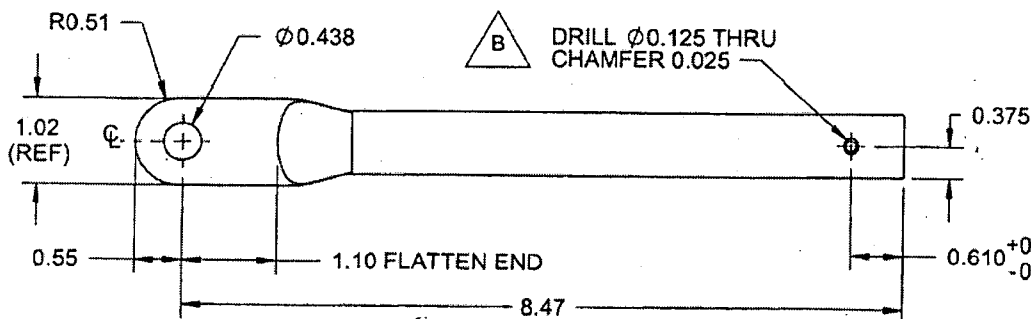
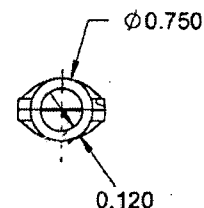
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3443	REV. B SHEET 3 OF 3
DATE 05.12.05	TITLE STRUT WELDMENT ASSEMBLY 1:2		

 $\phi 0.210^{+0.005}_{-0.010}$ **D3443-9 PIN****D3443-9 NOTES:**

- 1) MATERIAL: DELRIN II 150R OR ACETRON GP ACETAIL (REF. DART SPEC M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.12.09

DRILL $\phi 0.125$ THRU
CHAMFER 0.025 (TYP)**D3443-5 TUBING** $0.260^{+0.000}_{-0.030}$ **D3443-7 TUBING****D3443-5/-7 NOTES:**

- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC M304TR0.7500W.120)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

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